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D3340-13
Job Sheet 213672



Part No: D3340-13

Job Qty: 3 pcs

Part Name: Skidtube Protector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/20

Job Tracking No:

Due Date: 10/19/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: A 05.11.10 Preliminary issue AP/EC IPP Rev:B Now on Waterjet 06-10-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	3 pcs		10/17/20	0.17	0.56	Waterjet - Flow		on 20/10/08
110	QC 2	3 pcs		10/17/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/10/08
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120	QC 8	3 pcs	10/17/20	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Small Fab - Brake NC - B4B	3 pcs	10/17/20	0.25 0.18	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	QC 5	3 pcs	10/17/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	

DAS
82
9-89

OCT 09 2020

OCT 09 2020

OCT 13 2020

40

9-89

150 Powdercoat - 3 Grey Sand -
B4B3
pcs

10/19/20

0.00 0.13

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

Powdercoat - 5 - B4B

Powdercoat - 6 - B4B

Powdercoat - 7 - B4B

Powdercoat - 8 - B4B

Powdercoat - 9 - B4B

Powdercoat - 10 - B4B

M 138 839.

START : 1:35.

OUT: 30°

FINISH: 2:05.

20-10-13

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160 QC 3

3
pcs

10/19/20

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 68

QC 3 - 9

QC 3 - 40

QC 3 - 19

QC 3 - 43

QC 3 - 24

QC 3 - 61

QC 3 - 81

QC 3 - 82

QC 3 - 87

QC 3 - 47

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170 Packaging 3-1 - Stock - B4B

3
pcs

10/19/20

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

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OCT 14 2020

				Packaging 3 - 20 - B4B			
				Packaging 3 - 21 - B4B			
				Packaging 3 - 22 - B4B			
				Packaging 3 - 23 - B4B			
				Packaging 3 - 24 - B4B			
				Packaging 3 - 25 - B4B			
				Packaging 3 - 26 - B4B			
				Packaging 3 - 27 - B4B			
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
				Packaging 3 - 36 - B4B			
				Packaging 3 - 37 - B4B			
180 QC 21 - SA	3 pcs	10/19/20	0.00 0.00	QC 21 - SA - 21	DAS		
				QC 21 - SA - 70	28		
				QC 21 - SA - 9	9-89		
				QC 21 - SA - 77			
				QC 21 - SA - 28	OCT 14 2020		
Part Op 100 - 1-Cut as per Dwg D3340 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - (Bend/Assemble as per dwg), Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT 8326 and DT8261 140 - QC5- Inspect part completeness to step on W/O 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release							
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
M1010S20GA	1010/1025 Sheet	3,7800 sf (1.26 ea)	100-Waterjet - Flow - 1	5032206			
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
100-Waterjet - Flow - 1	M1010S20GA	4	68	0			
Part Specifications							
Specifications could not be found.							

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DART AEROSPACE LTD		Work Order: 213672
Description: Aft Skidtube Protector		Part Number: D3340-13
Inspection Dwg: D3340	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.247	1		Viper-04	
0.300	+/-0.010	.299	1		" "	
0.50	+/-0.030	.50	1		" "	
0.250	+/-0.010	.249	1		" "	
2.315	+/-0.010	2.314	1		" "	
2.815	+/-0.010	2.816	1		" "	
1.625	+/-0.010	1.629	1		" "	
23.125	+/-0.010	23.125	1		Tap	
26.625	+/-0.010	26.625	1		"	
52.315	+/-0.010	52.315	1		"	
55.815	+/-0.010	55.815	1		"	
58.190	+/-0.010	58.190	1		"	
61.000	+/-0.010	61.000	1		"	
63.565	+/-0.010	63.565	1		"	
0.040	+/-0.010	.038	1		"	

Measured by: <i>on</i>	Audited by: <i>DAS 82</i>	Preliminary Approval:
Date: 20/10/08	Date: OCT 09 2020	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

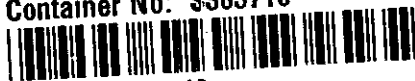
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S305710



Part: D3340-13

Job No: 213672

Serial No/Batch: S305710

Revision: 8

Inspector:

Exp Date:

Instructions: Various STC's

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